



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T102012
Job Sheet 167908



Part No: RB T102012

Job Qty: 1 ea

Part Name: Support Dolly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 4/16/18

Created By: Chantal Lavoie

Type: Stock

Description:

Customer: Africair Inc (CAFR101)

13551 SW 132nd Avenue Miami, FL, 33186 USA ph:(305) 255-6973

Ship Via:

ONE-TIME
APPROVAL BY
MARCEL (DQA)
4-5-18

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		4/16/18	0.00	0.00	Purchasing		AT 18/6/18
110	Packaging	1 pcs		4/16/18	0.00	0.00	Packaging2		AT 18/6/18
120	QC	1 pcs		4/16/18	0.00	0.00	QC6		
130	Packaging	1 pcs		4/16/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		4/16/18	0.00	0.00	QC21		

Part Op 100 - Issue P/O: _____ MANUFACTURE RB T102012 AS PER DWG Supplier: AIRCRAFT HARDWARE ACCESS
Descriptions: -Certificate of conformity is required

13
9-59

NOV 08 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	RB T102012P	1	0	0	0

Part Specifications

Specifications could not be found.

CONTAINER NO.

Support Dolly

PART NO: RB T102012

Serial No/Batch: S057644

Revision:

Operation:

Change No:

Packaging

Mfg Date: 04/03/18

Job No: 167908

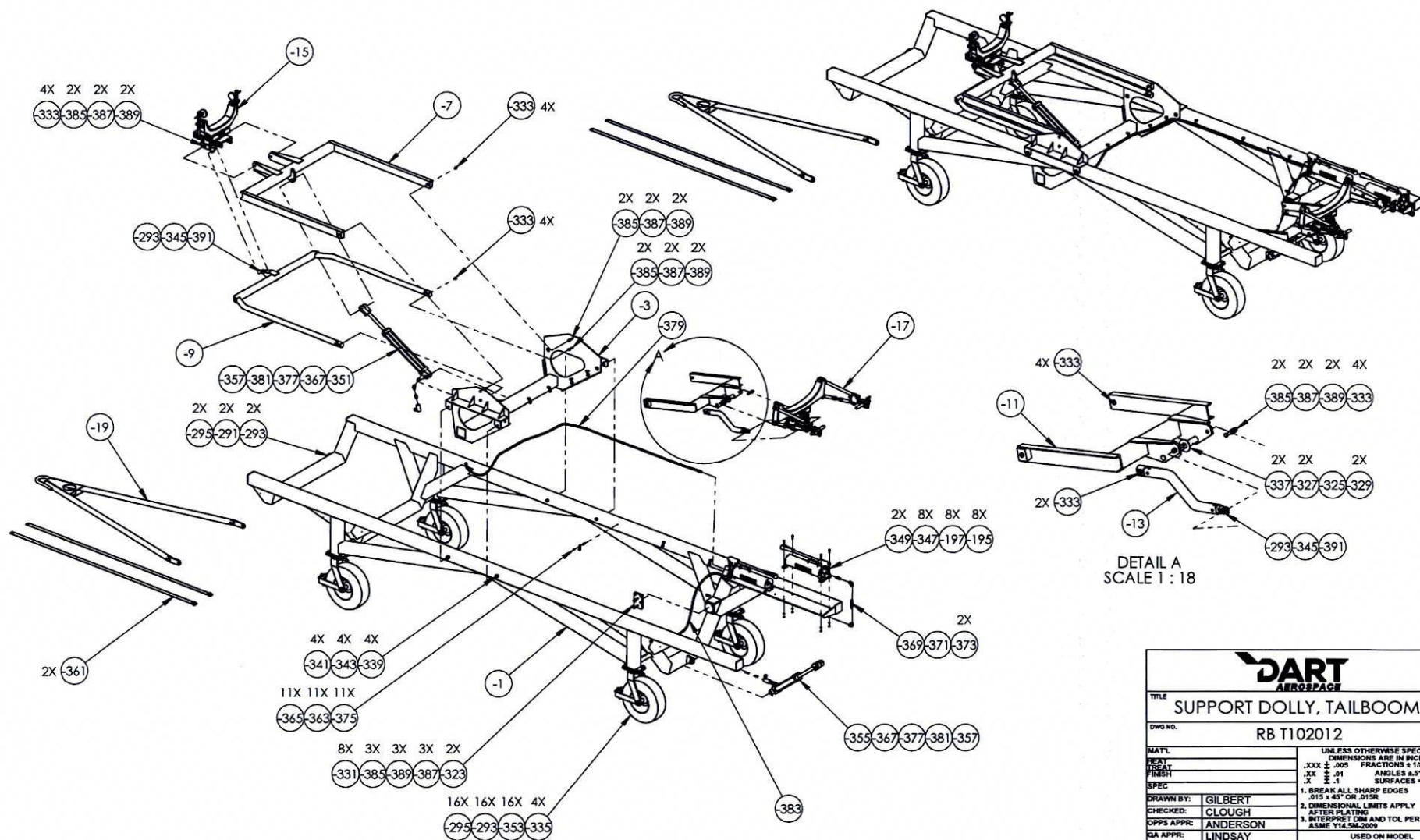
22 week LT. \$49,500 X 1

Purchased Part- Aircraft Hardware Access

Received 17-11-7

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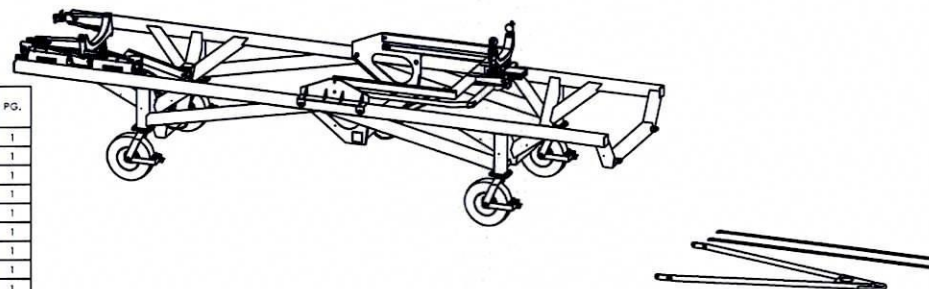
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		RELEASED FOR PRODUCTION.	5/3/2017	JAG



DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012	REV 1
MATL. _____	UNLESS OTHERWISE SPECIFIED
FINISH _____	DIMENSIONS ARE IN INCHES
SPEC _____	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES ± 125
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 ± .005 OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET CNA AND TOL PER ASME Y14.5M-2009
SCALE 1:36	DATE 3/27/2014
	SHEET 1 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

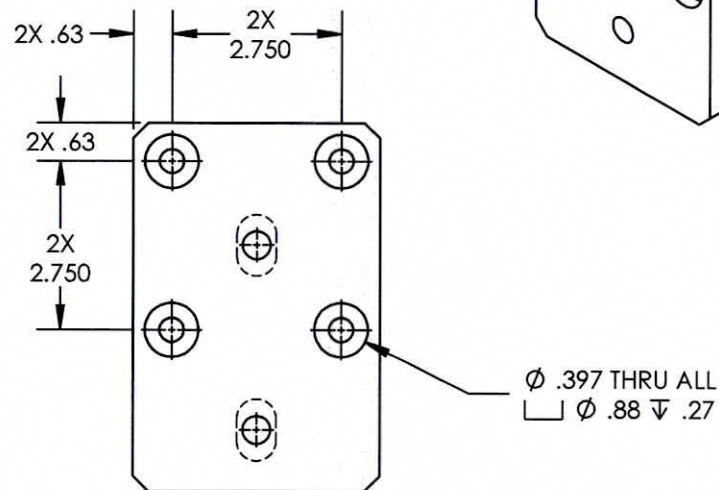
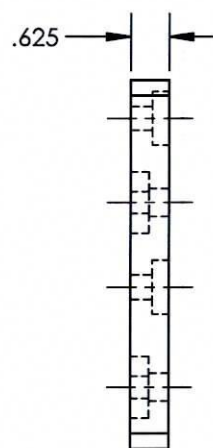
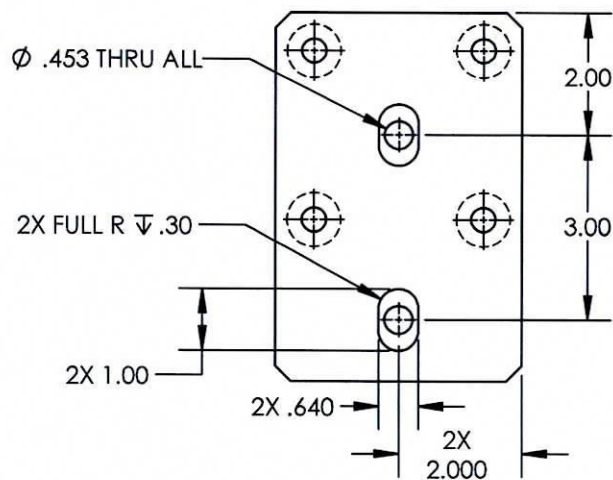
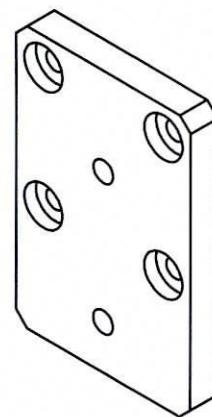


ASSY QTY	ASSY QTY	B/O	Part #	QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	MAIN FRAME		RB T102012-1	1
			-3	1	FRONT PIVOT SUPPORT ASSEMBLY		RB T102012-3	1
	X		-5	1	LIFT ARM WELDMENTS		RB T102012-5	1
1			-7		TOW BAR ARMS UPPER ASSEMBLY			1
1			-9		TOW BAR ARMS LOWER ASSEMBLY			1
1			-11		REAR ARM ASSEMBLY			1
1			-13		REAR ARM STABILIZER ASSEMBLY			1
			-15	1	TOW SIDE LIFT		RB T102012-15	1
			-17	1	REAR LIFT ASSEMBLY		RB T102012-17	1
			-19	1	TOW BAR ASSEMBLY		RB T102012-19	1
	B/O		-195	8	HEX NUT	STEEL	5/16-18 (MCMASTER-CARR #95462A030)	1
	B/O		-197	8	WASHER	STEEL	Ø5/16 (MCMASTER-CARR #95229A450)	1
	B/O		-291	2	HEX HEAD CAP SCREW	STEEL	1/2-20 X 2 (MCMASTER-CARR #91257A748)	1
	B/O		-293	20	WASHER	STEEL	Ø1/2 LD. (MCMASTER-CARR #90126A033)	1
	B/O		-295	18	HEX NUT	STEEL	1/2-20 (MCMASTER-CARR #94895A825)	1
			-323	2	MAIN FRAME 1 PIVOT PLATE	A36/1018/1020 HR		3
			-325	1	PIVOT ROD	4140/4142		4
			-327	2	PIVOT ROD SLEEVE	A513		5
	B/O		-329	2	ROLL PIN	STEEL	Ø1/8 X 1-1/4 (MCMASTER-CARR #90692A701)	1
	B/O		-331	8	BOLT	STEEL	3/8-24 X 1 (MCMASTER-CARR #92865A215)	1
	B/O		-333	22	FLANGE BEARING	BRONZE	SYMCO #5F-1420-10	1
			-335	4	CASTER ASSY		RB T102012-335	1
	B/O		-337	2	WASHER	STEEL	Ø1 (MCMASTER-CARR #90108A038)	1
	B/O		-339	4	BOLT	STEEL	5/8-16 X 5-1/2 (MCMASTER-CARR #91247A449)	1
	B/O		-341	4	WASHER	STEEL	Ø5/8 (MCMASTER-CARR #90126A035)	1
	B/O		-343	4	NYLOCK NUT	STEEL	5/8-18 (MCMASTER-CARR #95615A260)	1
	B/O		-345	2	ROD END		MCMASTER-CARR #60645K161	1
	B/O		-347	8	BOLT	STEEL	5/16-18 X 1-1/4 (MCMASTER-CARR #92865A585)	1
	B/O		-349	2	HYDRAULIC PUMP	ENERPAC P80 MSC #80021603		1
	B/O		-351	1	HYDRAULIC CYLINDER	PRINCE #B200180ABAAA078		1
	B/O		-353	16	BOLT	STEEL	1/2-20 X 1-1/2 (MCMASTER-CARR #92620A746)	1
	B/O		-355	1	HYDRAULIC CYLINDER	PRINCE # B200100ABAAA078		1
	B/O		-357	2	FLOW CONTROLLER	PRINCE # WFC-600		1
	B/O		-361	2	STRAP	RED NYLON WEBBING	90" X 1.5" (STAN'S UPHOLSTERY)	6
	B/O		-363	11	HOSE CLAMP	STEEL	Ø3/4 (MCMASTER-CARR #3225T6)	1
	B/O		-365	11	STANDOFF	STEEL	1/4-20 X 3/4 (MCMASTER-CARR #93620A194)	1
	B/O		-367	2	ADAPTER FITTING	STEEL	MALE 3/4-16 UNF TO MALE 3/8" NPTF (MCMASTER-CARR # 50925K331)	1
	B/O		-369	1	PIPE NIPPLE	304 S.S.	3/8 NPT X 3-1/2 (MCMASTER-CARR #46755K133)	1
	B/O		-371	1	PIPE NIPPLE	316 S.S.	3/8 NPT X 2 (MCMASTER-CARR #4475K33)	1
	B/O		-373	2	ELBOW	STEEL	FEMALE TO FEMALE 3/8 NPTF (MCMASTER-CARR #50925K153)	1
	B/O		-375	11	SCREW	S.S.	1/4-20 X 1/2 (MCMASTER-CARR #91772A537)	1
	B/O		-377	2	45° ELBOW	STEEL	MALE 3/8" NPTF TO FEMALE 3/8" NPTF (MCMASTER-CARR # 50925K181)	1
	B/O		-379	1	LOWER FRONT HOSE ASSY		MALE 3/8 NPTF END FITTINGS, Ø 3/4, 130 IN LENGTH	1
	B/O		-381	2	SWIVEL FITTING	STEEL	MALE 3/8" NPTF TO FEMALE 3/8" NPT (MCMASTER-CARR # 5340K36)	1
	B/O		-383	1	REAR HOSE ASSEMBLY		MALE 3/8 NPTF END FITTINGS, Ø 3/4, 98 IN LENGTH	1
	B/O		-385	11	BOLT	STEEL	7/16-20 X 3 (MCMASTER-CARR #91257A704)	1
	B/O		-387	11	WASHER	STEEL	Ø7/16 (MCMASTER-CARR #95229A520)	1
	B/O		-389	11	NYLOCK NUT	STEEL	7/16-20 (MCMASTER-CARR #95615A190)	1
	B/O		-391	2	PIN W/ HARFIN	STEEL	1/2 X 1-1/4 (MCMASTER-CARR # 97245A709)	1
ASSY	-5							

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ±.5° .X ± .1 SURFACES ±.125 1. BREAK ALL SHARP EDGES .015 ±.45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
DRAWN BY: GILBERT CHECKED: CLOUGH DVPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
SCALE 1:46	DATE 3/27/2014
SHEET 2 OF 6	

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REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



(323)

MAIN FRAME 1 PIVOT PLATE

DART AEROSPACE	
TITLE: SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-323	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± .5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:3	DATE 3/13/2014 SHEET 3 OF 6

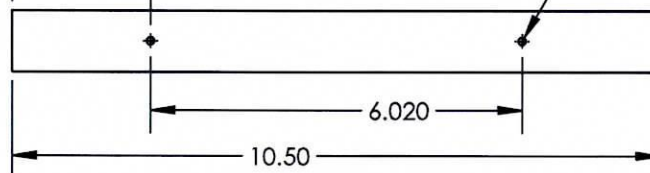
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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

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.995



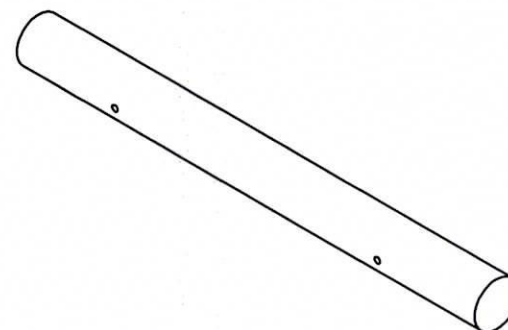
2.24



6.020

10.50

2X Ø .129
.125 THRU ALL



-325

PIVOT ROD



TITLE SUPPORT DOLLY, TAILBOOM

DWG NO. RB T102012-325

REV 1

MAT'L 4140/4142

TREAT RC 28-34

FINISH ZINC PLATE

SPEC ASTM B633 TYPE I SC 2

DRAWN BY: GILBERT

CHECKED: CLOUGH

OPPS APPR: ANDERSON

QA APPR: LINDSAY

APPROVED: GILBERT

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/8

.XX ± .01 ANGLES ± 5°

.X ± .1 SURFACES = 125/

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

USED ON MODEL

212,214B,214ST, & 412

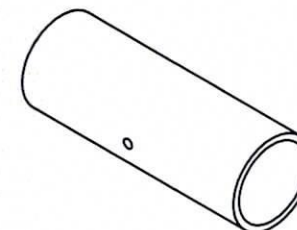
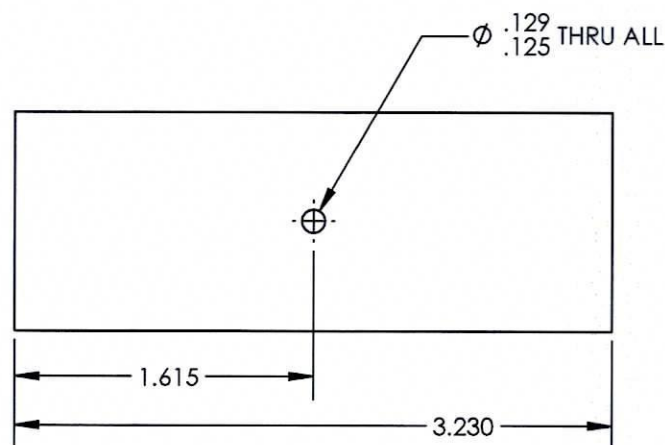
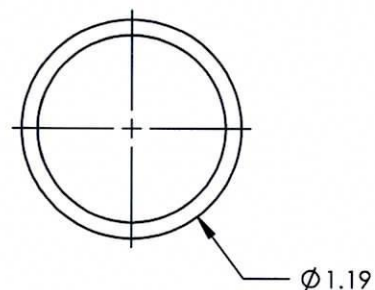
SCALE 1:3

DATE 3/26/2014

SHEET 4 OF 6

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



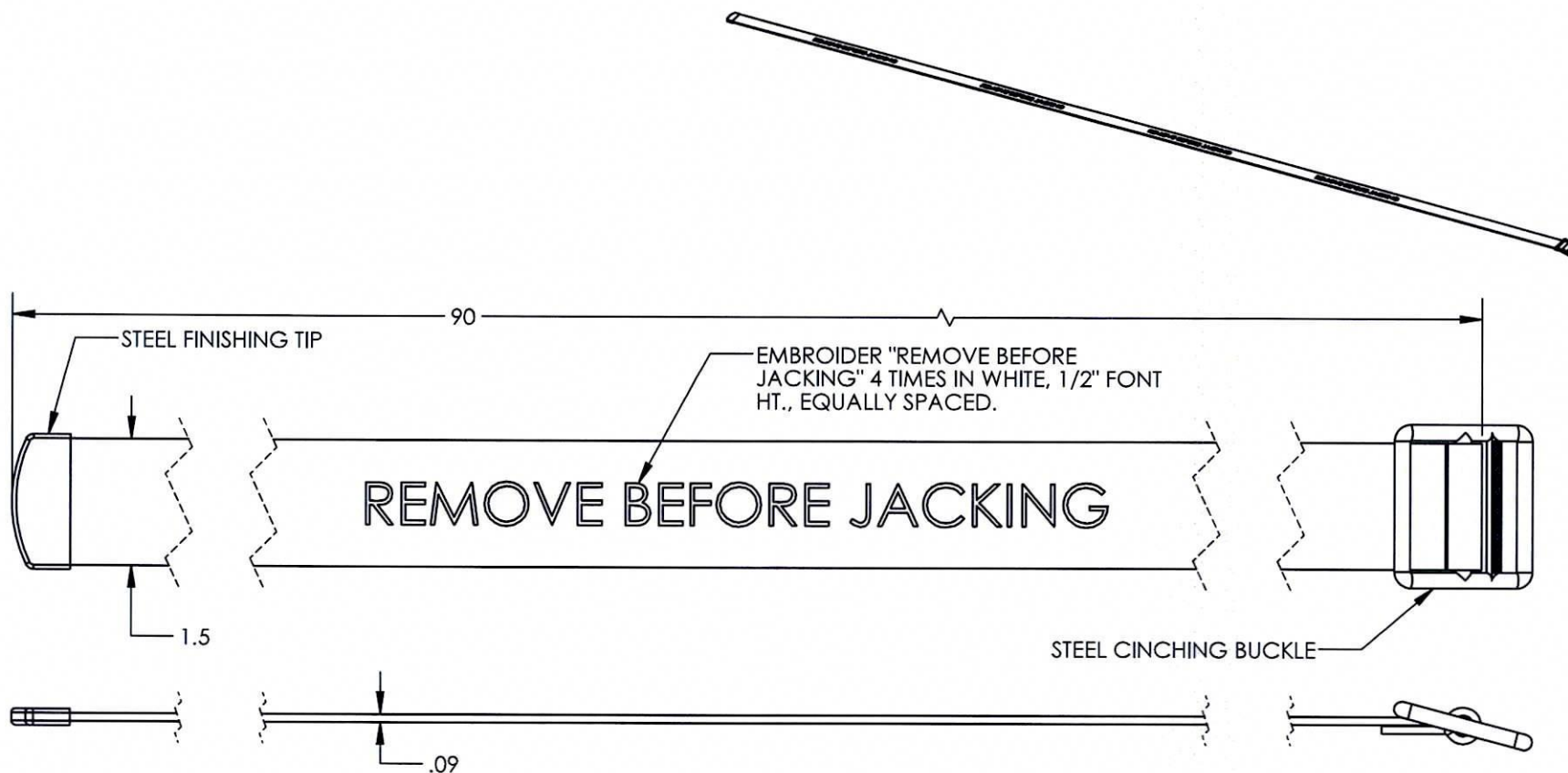
(-327)

PIVOT ROD SLEEVE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-327	REV 1
MAT'L A513	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .005 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 3/26/2014	212,214B,214ST, & 412
SHEET 5 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



(-361)

STRAP

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-361	REV 1
MAT'L RED NYLON WEBBING	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	
APPROVED: GILBERT	212, 214B, 214ST, 412
SCALE 1:2	DATE 11/16/2016 SHEET 6 OF 6





Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038296

Supplier: AIH001-VU
Aircraft Hardware and Accessories
P.O. Box 14007
Ft Worth, TX 76617 USA

PO No: PO038296

PO Date: 11/8/17

Due Date: 4/16/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Pynt Terms: Net 30

Freight Terms:

Special Comments:

NOV 08 2017

Items

Line Item	Part	Rev	Supplier Part No	Item No	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RB T102012P	-			Support Dolly		Firmed	4/16/18	1 Ea	0 Ea	1 Ea	\$48,500.00/Ea	\$48,500.00

Line Item Note b167908

Grand Total: \$48,500.00

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/8/17 10:21 AM dart.lavoie.chantal

AIRCRAFT HARDWARE & ACCES.

P.O. BOX 14007 FT. WORTH TX 76117

Phone: 817-680-3523 FAX- 817-416-5274

e-mail: sales@aircrafthardwareacces.com

Packing Slip

ATTN: Shipping Dept.

Date: 3/28/2018

TO: DART AEROSPACE

1270 ABERDEEN STREET

Hawkesbury ON K6A1K7

Packer # 32818

Cust. PO #: 38296

Qty	Tool #	REF#	Description
0	RBT102012		SUPPORT DOLLY

ALL MATERIALS, PARTS OR COMPONENTS HAVE BEEN INSPECTED
AND COMPLY WITH THE PURCHASE ORDER REQUIREMENTS

Metal Work Specialties

PO Box 1367

3192 E Hwy 114

Boyd, Texas 76023

Phone: 940-433-3427

klinemws@embarqmail.com

Certificate of Conformance

Date: April 3, 2018

Company name: Aircraft Hardware & Acces

PO Number: SA 110817

MWS hereby certifies that the following items furnished against the above order conforms to the specifications noted below

Quantity: 1

Part Number: RBT 102012

Specifications: Mfg to Aircraft Hardware & Acces. provided Dwg.

Authorized signature: Mike F Kline

Mike Kline